

ASAP

Dart Aerospace Ltd.

Date: Thursday, 1/4/2007 7:38:00 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LARGE ENGINE MOUNT
Job Number : 30163	
Estimate Number : 12624	
P.O. Number : N/A	Part Number : D2127251111
This Issue : 1/4/2007 S.O. No. : N/A	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 1/11/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 5 Um: Each
Comment : Est Rev:A New Issue 06-12-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB1500X15000	AISI 4140 Steel Bar
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Comment: Qty.: 0.4286 f(s)/Unit Total : 2.1431 f(s)
 AISI 4140 Steel Bar 1.500" X 1.500"
 Batch: M102949

J.F. 07/01/04

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank 4.900" long

J.F. 07/01/04

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA658 and Dwg D212-725-1

J.F. 07/01/04

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/01/04

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.G. 07/01/05

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: Pu 7/01/05 (5)

pkg for Eagle

[Handwritten notes and signatures]
 - 2.000 210: 1 5195 1 06/07/02/09
 - 2.000 210: 1 5195 1 06/07/02/09
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Drawing Name: LARGE ENGINE MOUNT

Job Number: 30163

Part Number: D2127251111

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

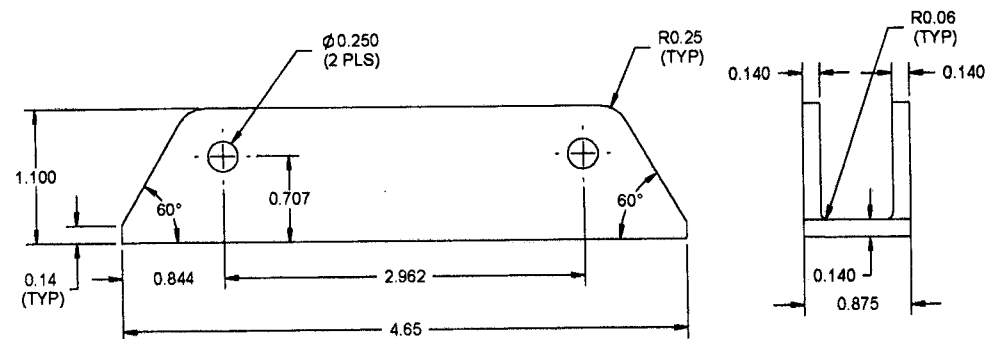
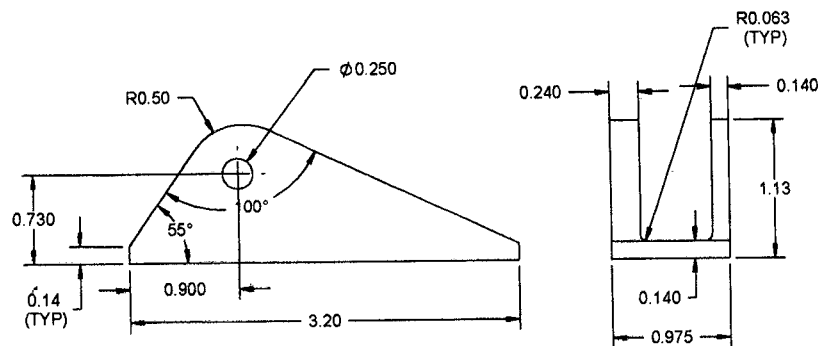
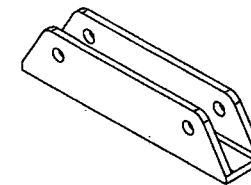
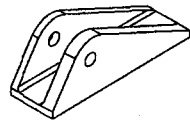
07/01/09 (5)

Job Completion



u 07 01.09

REFERENCE ONLY



D212-725-1-109 SMALL ENGINE MOUNT
D212-725-1-110 OPPOSITE

D212-725-1-111 LARGE ENGINE MOUNT

D212-725-1-109/-110/-111 NOTES:

- 1) MATERIAL: AISI 4140/4130 STEEL BAR PER MIL-S-5626/-6758 OR AMS 6382/6349/6529 OR AMS 6348/6370/6528 (REF. DART SPEC. M4140N-B OR M4130N-B) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN JL	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 35 OF 37
DATE 06.12.08	TITLE 212S DETAIL PARTS		SCALE 1:
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